

Date: Monday, 18/08/2008 10:22:40 AM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FWD TUBE ASSEMBLY
 Job Number : 41276
 Estimate Number : 10467
 P.O. Number :
 This Issue : 18/08/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D3391021
 First Issue : / / Type : SKIDTUBES Drawing Number : D3391 REV G
 Previous Run : 41275 Project Number : N/A
 Material :
 Due Date : 08/09/2008 Qty: 1 Um: Each

Written By :
 Checked & Approved By : JLD 08.8.18

Comment : Est. A 05.09.13 New issue KJ/JLM
 Est. B 06.02.10 Dwg rev.D ecn 773 EC
 Est. C 06.05.02 Added inspections EC
 est D 07.03.13 rev F dwg EC
 est E 07.11.07 revG dwg ecn1053P EC verified by: DD
 Est Rev:f ECN 1056 07-11-12 DD verified by: EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6013047 Skidtube Material



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE MAT'L

Pick:

Qty Part Number Description Batch
 1 D6013-047 Extrusion

Batch

B-26547

AWM

8-8-18

2.0 SKIDTUBES 1 SKIDTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Cut extrusion to 46.52 +0.010 -0.020

AWM 8-8-18

3.0 BENDING BENDING MACHINE - SKIDTUBES



Comment: No bender

Bend as per Dwg D3391 Using Bend Prog 3391021

2T 08-08-19

4.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 8-8-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: FWD TUBE ASSEMBLY

Job Number: 41276

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



90

Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA590 Rev. ____ & Dwg D3391 Rev. ____

Identify as D3391-1

2-Deburr

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill X1 Aft cap as per Dwg D3391 .1875" dia

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5-Deburr & Scribe Batch number Inside aft end.

6-Transfer drill D3391-021 with D3391-023

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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8/9/14	#5.0	Pant scraped due to the 0.687" cut out for the inner mounting Ridge is off. Tube was tested in nip tube and	<i>[Signature]</i>	SCRAP and destroy no Replace Qty (4)	<i>[Signature]</i> 8/9/14	<i>[Signature]</i> 08/09/14	<i>[Signature]</i> 08/09/14	<i>[Signature]</i> 08/09/14
		work side SLIDE in. P.C. operator on other shift put wrong end angle plate on setup > LACK of	<i>[Signature]</i>			<i>[Signature]</i> 08-09-14	<i>[Signature]</i> 08/09/14	<i>[Signature]</i> 08-09-14
		Attention.						

NOTE: Date & initial all entries

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Part Number: D3391021

Job Number:



Seq. #:	Machine Or Operation:	Description :
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11.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0	D36704200	SPACER
------	-----------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch: _____

15.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-instal spacers as per dwg D3391

A/R Magnabond 6398 batch: _____

exp. date: _____

cure time 12hrs. as per QSI015

2- grind crossbolt flush

3-back drill crossbolt if necessary

16.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

17.0	POWDER COATING	POWDER COATING
------	----------------	----------------



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: _____

OVEN TEMPERATURE: _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: FWD TUBE ASSEMBLY

Job Number: 41276

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

FINISH TIME: _____

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

19.0

ALS41032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

batch: _____

or equivalent

per QSI 017

20.0

ALS41032225

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

INSERT

batch: _____

or equivalent

per QSI 017

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

22.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

23.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Cap Assembly

Pick:

Qty	Part Number	Description	Batch
1	D3401-041	Tow Cap	_____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NQN-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

D356413

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARSHOE

25.0

D356613

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET

26.0

D36721

Phenolic Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
PHENOLIC WASHER

27.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Bolt
Pick:
Qty Part Number Description Batch
4 AN3C4A Bolt

28.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
washer

29.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Install tow Cap as per Dwg D3391
Identify as D3391-021

30.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Inspect thread of each insert using DT8821

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 41276

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

32.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 88-09-05

Scrap

Dart Aerospace Ltd

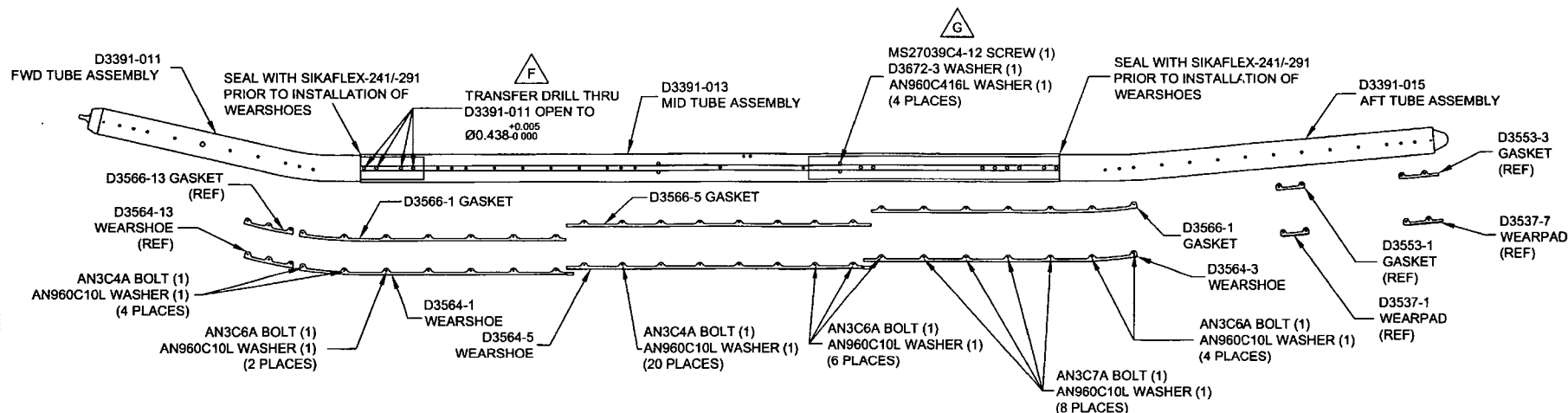
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3391-041 ASSEMBLY

RELEASED
07-11-06

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
4	D3572-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
3	AN960C10L	WASHER
4	MS27039C4-12	SCREW
1	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

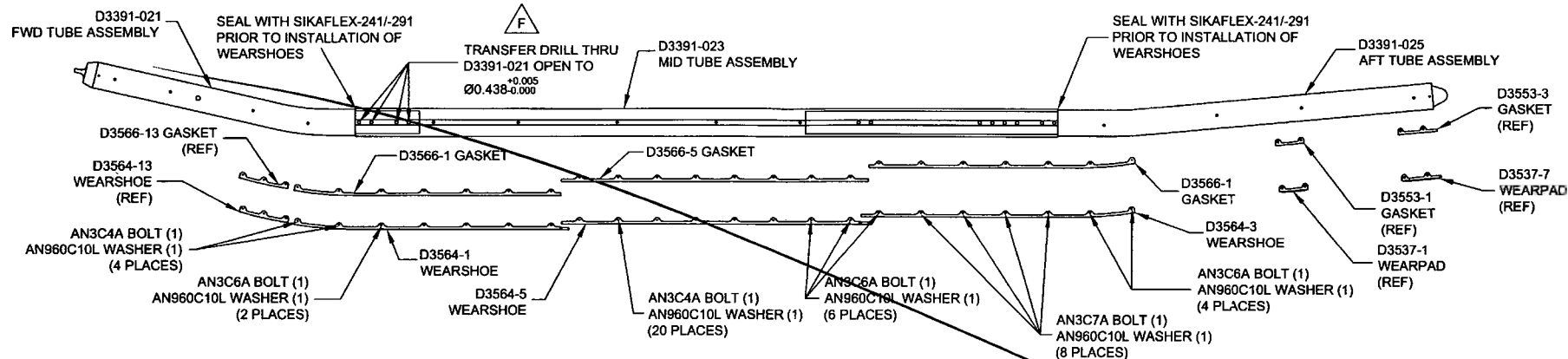
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.31		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3391
REV. G
SHEET 1 OF 8
TITLE 412 FLOAT SKIDTUBE
NTS

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D3391-043 ASSEMBLY

RELEASED
07.11.91

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

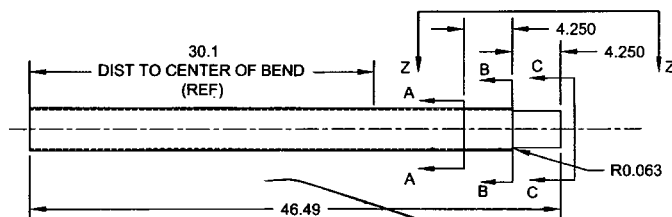
QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
2	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
6	AN3C7A	BOLT
44	AN960C10L	WASHER

GENERAL NOTES

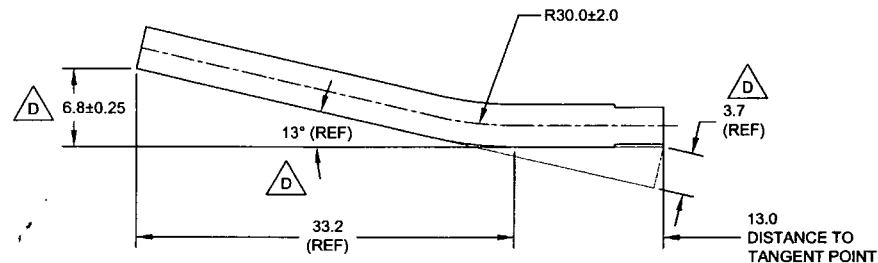
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL $\varnothing 0.297$ SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

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MFG. APPR.	JJC	D3391	SHEET 2 OF 8
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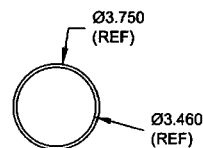
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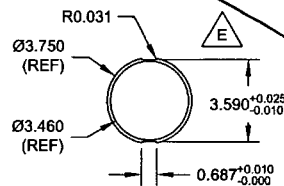
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



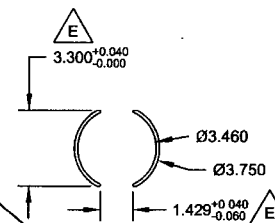
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



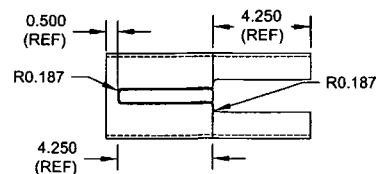
SECTION A-A
(SCALE 1:5)



SECTION B-B
(SCALE 1:5)



SECTION C-C
(SCALE 1:5)

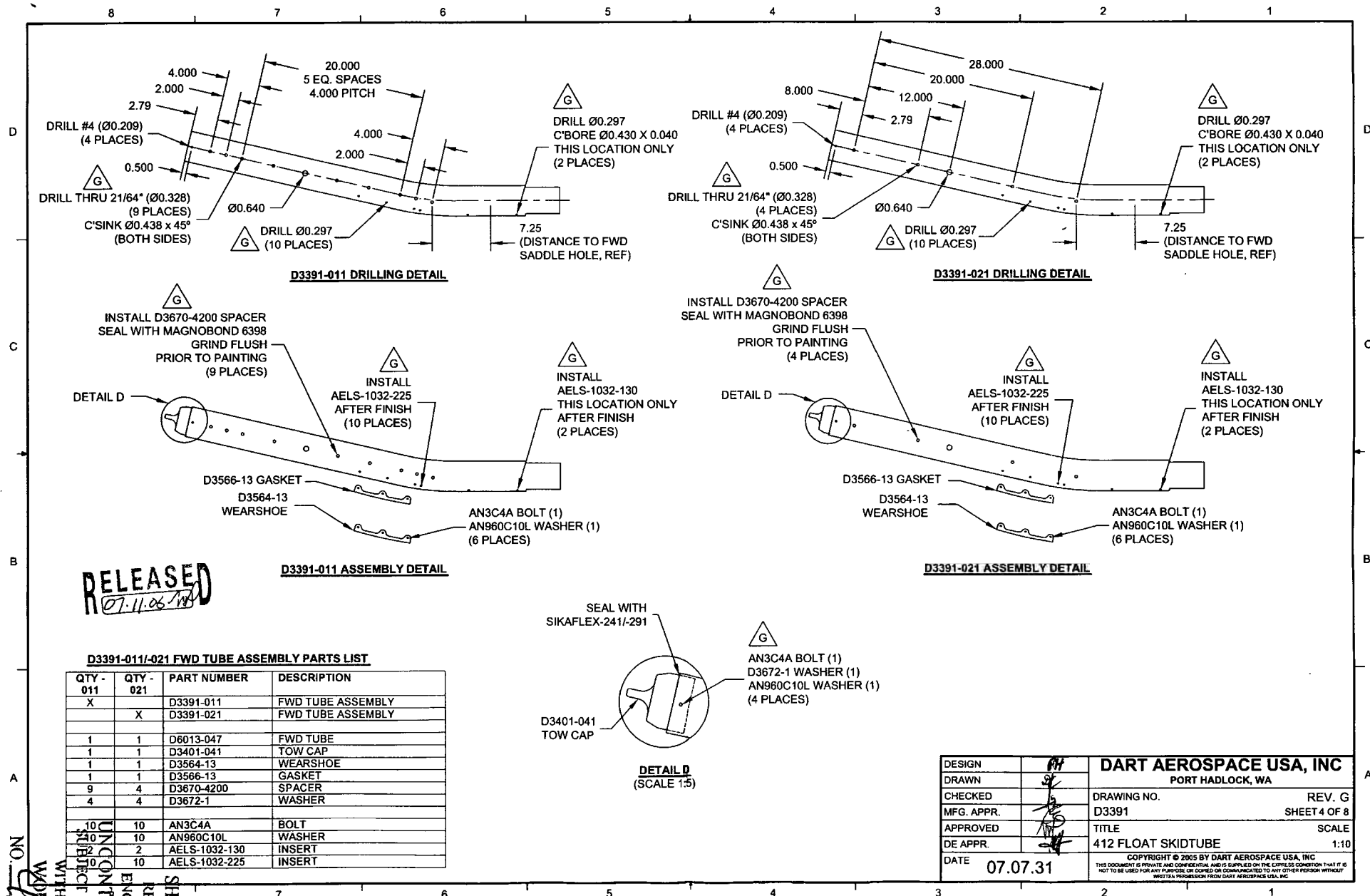


VIEW Z-Z
(SCALE 1:5)

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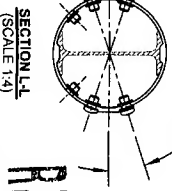
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CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D3391	SHEET 4 OF 8
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DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	
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QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
12	D3389-1	WEB
4	D3672-1	SPACER
4	D3672-3	WASHER
24	ALS-1032-130	INSERT
4	ALS4-428-165	WASHER
4	AN980C10L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

UNLESS OTHERWISE SPECIFIED
MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
INSTALL D3391-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER OSI 015

DRILL Ø0.391
INSTALL ALS4-428-165 INSERT
MS27039C4-08 SCREW
D3672-3 WASHER
AN980C416L WASHER
AFTER FINISH
(TYP 4 PLACES)

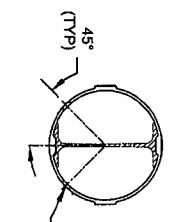


RELEASED
07.11.2017

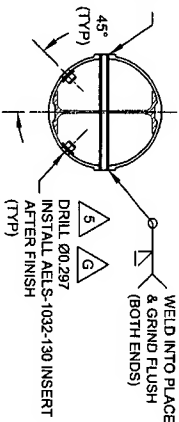
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CHECKED		DRAWING NO.
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APPROVED		TITLE
DE APPR.		412 FLOAT SKIDTUBE
DATE	07.07.31	SCALE
		1:20

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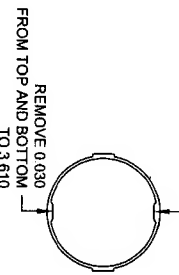
SECTION G-G
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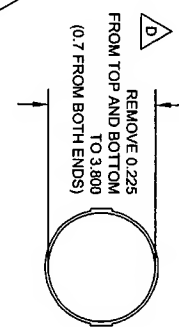
SECTION H-H
(SCALE 1:4)



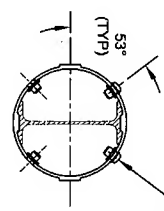
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(SCALE 1:4)



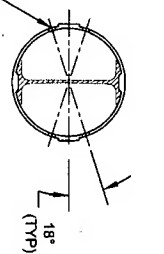
SECTION Y-Y
(SCALE 1:4)



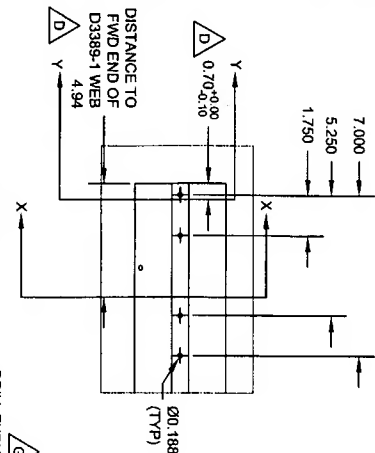
SECTION M-M
(SCALE 1:4)



SECTION L-L
(SCALE 1:4)

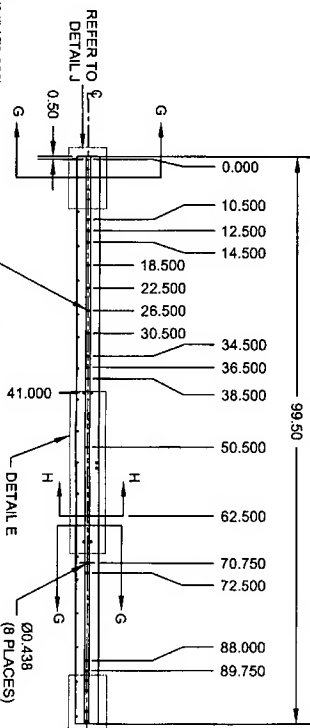


DETAIL J
(SCALE 1:5)

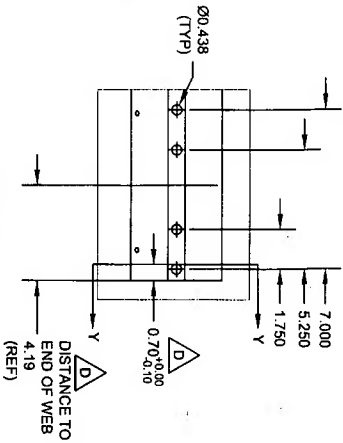


DRILL THRU 21/64" (Ø0.328)
CSINK Ø0.438 X 45° (BOTH SIDES)
(12 PLACES)

D3391-013 ASSEMBLY DETAIL



DETAIL K
(SCALE 1:5)



8 7 6 5 4 3 2 1

D

C

B

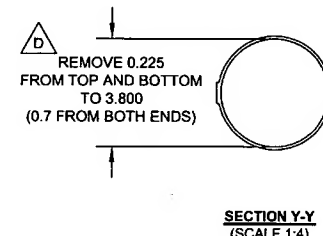
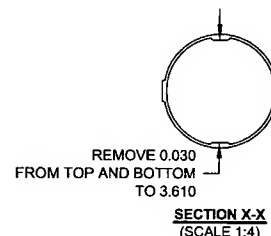
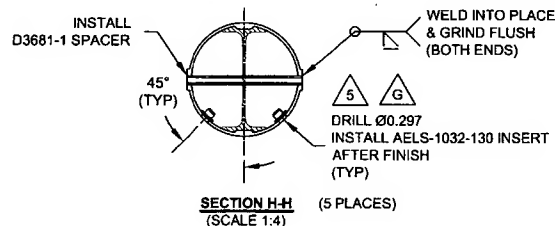
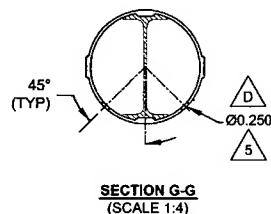
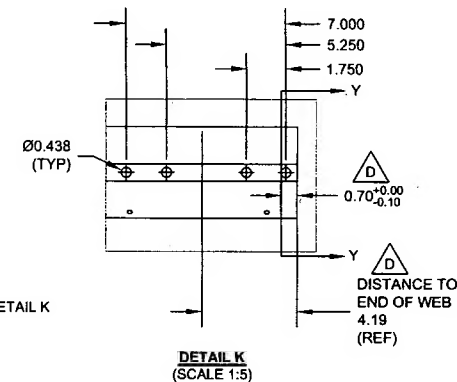
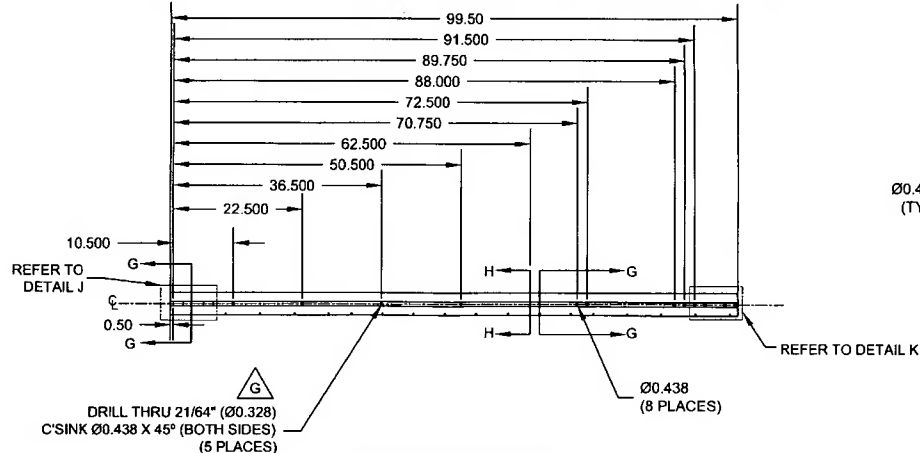
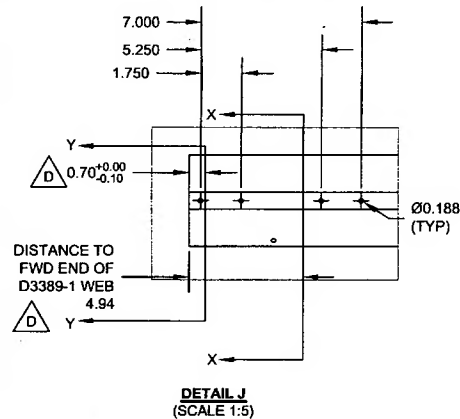
A

D

C

B

A



D3391-023 MID TUBE ASSEMBLY PARTS LIST

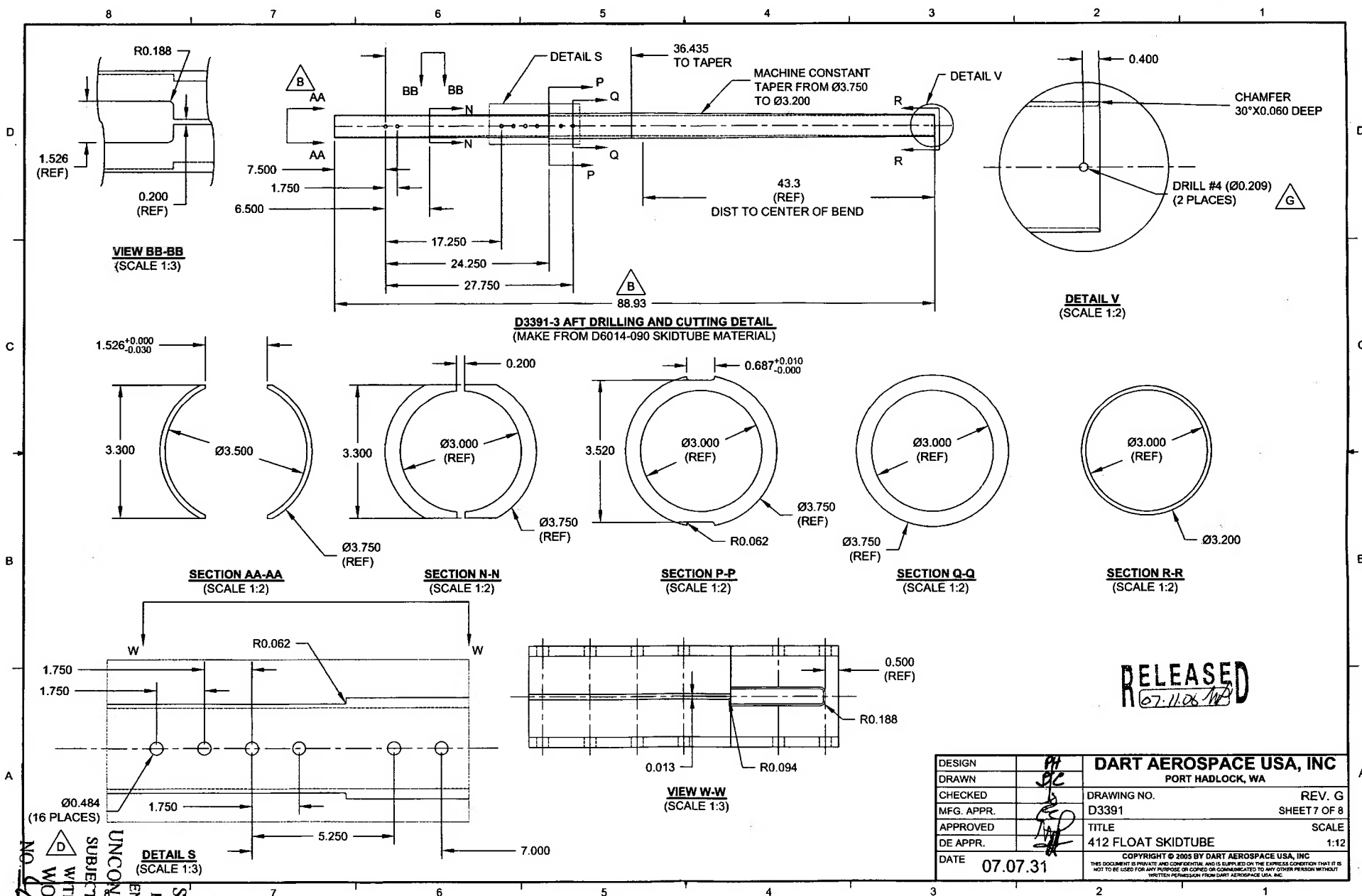
QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

RELEASED
07-11-06/11

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	DE	PORT HADLOCK, WA	
CHECKED	DE	DRAWING NO.	REV. G
MFG. APPR.	DE	D3391	SHEET 6 OF 8
APPROVED	DE	TITLE	SCALE
DE APPR.	DE	412 FLOAT SKIDTUBE	1:20
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC	

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D3391-023 MID TUBE ASSEMBLY
MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
WELDING PER DART QSI 004



NO. 41270

WORK ORDER

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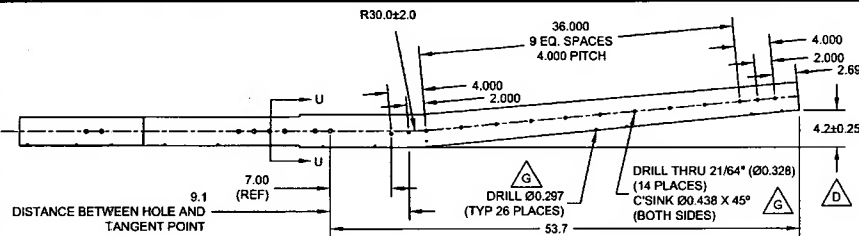
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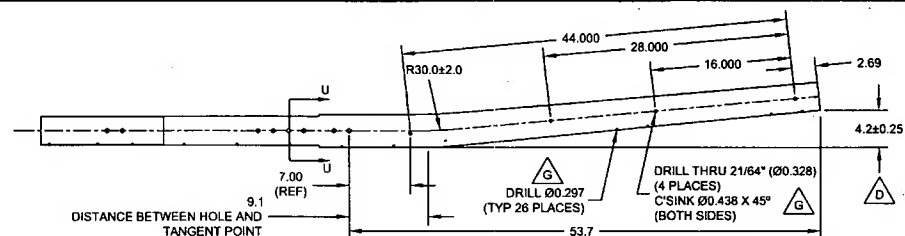
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D3391-015 BENDING AND DRILLING DETAIL
(SEE C'BORE DETAIL BELOW)

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
(14 PLACES)



D3391-025 BENDING AND DRILLING DETAIL
(SEE C'BORE DETAIL BELOW)

INSTALL D3670-4200 SPACER
SEAL WITH MAGNOBOND 6398
GRIND FLUSH
PRIOR TO PAINTING
(14 PLACES)

D3391-015 ASSEMBLY AND C'BORE DETAIL
(SEE TABLE)

AN3C5A BOLT (1)
AN960C10L WASHER (1)
(4 PLACES)

AN3C4A BOLT (1)
AN960C10L WASHER (1)
(4 PLACES)

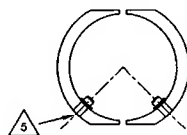
D3391-025 ASSEMBLY AND C'BORE DETAIL
(SEE TABLE)

AN3C5A BOLT (1)
AN960C10L WASHER (1)
(4 PLACES)

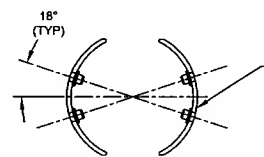
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(4 PLACES)

D3391-015-025 AFT TUBE ASSEMBLY PARTS LIST

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2646	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3553-1	GASKET
1	1	D3553-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

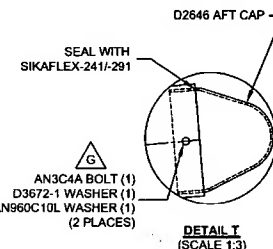


SECTION U-U
(SCALE 1:3)



SECTION CC-CC
(SCALE 1:3)

DRILL Ø0.391
C'BORE Ø0.516 X 0.040 DEEP
INSTALL ALS4-428-165 INSERT (1)
(4 PLACES)



DETAIL T
(SCALE 1:3)

RELEASED
07-11-06

C'BORE HOLES MARKED CB1-CB4 AS FOLLOWS AND
INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	C'BORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	OK	PORT HADLOCK, WA
CHECKED		DRAWING NO. REV. G
MFG. APPR.		D3391 SHEET 8 OF 8
APPROVED		TITLE SCALE
DE APPR.		412 FLOAT SKIDTUBE 1:12
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